Page 1

June-20-15 12	33.30 T M									
Item ID: Revision ID:	D3901-1		· A	Accept	*N900	<u>0401</u> (	)U*	Setup Star	14,	S1*
Item Name:	Bar		·					Stop	, */IC	<b>S2*</b>
Start Date:	6/20/13	<b>Start Qty: 20.00</b>	*20*		Cust Item II	D·				
Required Date:	7/04/13	Req'd Qty: 20.00	*20*		Customer:					
Reference:			7(1		customer.					
Approvals:	Process Plan	1: MLJ	Date: 13-06-20	Tooling:	Da	te:		Run Star	I.ZI F	₹1*
	QC:		Date:	SPC (Y/N):	Da	te:		Stop	' *NF	₹2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool # Pla		Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revis	sion Nbr								
D3901	E			•			1. <del>2</del> 1	t -		
100 *100* Gold Saw		Memo		0.00	m/ 13/07	2/2/	20	) <u></u>	<b>+</b>	
Hyd Mech		Cut blanks a	t 55.1875"							
110				0.00		,	• <b>7</b> , 4 * •			
*110* HAAS I		Memo		0.00	Zef 13.	7. 24	20	) <u>b</u>		· · · · ·
HAAS CNC vertical	machine #1	1-Mill as per FOLIO REV DWG REV:_	folio FB090 & dwg D3901,							
ţ		2-Deburr as i	required		v*	,				

DQA:			Date:		<del></del>								`	TRAGG <sup>*</sup>
QA Closed:			Date:			WORK ORDER NON-	-C(	ONFO	RMANCE / UPDATE	Wo	ork Order up	odate only $\Gamma$	$\neg$	AEROSPACE
Work Orde	. r.					DISPOSITION			AGAINST		PARTMENT			
WORK Orde					—	Rework			Chief tube Creestube		1	14/ata# Jat	$\neg$	Carina anima [
Part N	do.					Scrap			Skid-tube Crosstube  Machining Small Fab	$\overline{}$	Dro	Water Jet d. Eng. Coor.	$\dashv$	Engineering Quality
Tarer	<b>'</b>				_	Use-as-is			noforming Finishing		1	re/Packaging	$\dashv$	Other
NCR N	No.					Suspected Unapproved		incii	Large Fab Composite	$\overline{}$	Nec/3tol	Supplier	$\dashv$	Other
				·	<del></del>				24.85 . 42		l	oupplie! [		
Root					Desci	ription of work order update	1	nitial	Action		Sign &		$\top$	· · · · · · · · · · · · · · · · · · ·
Cause	_   [	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	,	QC Inspector
Design													$\top$	
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator														
Offset/Setup														
Process														
Supplier														
Training	Ш													
Transport												•		
Unapproved														
							FAL	JLT CAT	TEGORY					
Landi	ng Gea	r				General					•			
	Be	nding			<u> </u>	Bend		Folio/P	Program		Outside Dim	ensions	P	ressure/Forced
	Ce	ntre No	t Concen	ntric		BOM/Route		Grain			Over/Under	tolerance	s	Set-up
		acks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ct _		emperature/Cure
	Cri	mp/Kin	k/Ripple,	/Wave		Burrs		Inspecti	ion Incomplete/Unqualified		Part Lost/Mi	ssing	\v	Veld
	Cu					Contamination		Instruct	tions Incomplete/Unclear		Part Moved		\v	Vrong Stock Pulled
		ushing				Countersink		Misalig	gned/off center		Positioned W		_	
	_	at Treat				Cut Too Short		Mislabe	eled		Power Loss/:	Surge	c	Other
	Ins	pection	Strip in	Tube		Drawing		Misread	b					
	<u></u> Ма	arks/Cha	atter			Drill Holes		Off-set						
	_	_	equence			Finish		Out of 0	Calibration					
	l lw:	ave/Twi	st in Tub	P		Fit/Function		Out of 9	Seguence					

Insp.

\*103293\* June-20-13 12:35:58 PM Item ID: D3901-1 Accept \*N900040100\* Setup Start \* N **Revision ID:** Item Name: Bar Start Date: 6/20/13 **Start Oty: 20.00** \*20\* Cust Item ID: Required Date: 7/04/13 Req'd Qty: 20.00 \*20\* **Customer:** Reference: Run Process Plan: \_\_\_\_ Date: Approvals: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Work Center ID Description **Run Hours** Code Qty Number Stamp Qty 120 QC2- Inspect parts off machine FAI/FAIB 0.00 20 13.7.24 20 0 \*120\* 0.00 Memo Quality Control \*\*\*EXTRA MATERIAL WILL BE CUT ON ASSEMBLY\*\*\* 130 OC8- Inspect parts - second check 0.00 and 13/07/25 20 1 \*130\* 0.00 Memo Quality Control \*\*\*EXTRA MATERIAL WILL BE CUT ON ASSEMBLY\*\*\*

140

\*110\*

Packaging

Packaging

Identify as per dwg & Stock Location: WAON

0.00

Memo

0.00

20 13-07-25 MAL

DQA:			Date:							22.475			
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / U		Vork Order u	odate only	AEROSPACE
Work Orde						DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
WOIK OIGE	-1.				-	Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	J۸					Scrap		1	Vachining	Small Fab	Pro	d. Eng. Coor.	Quality
· · · · · · · · ·	•••					Use-as-is			noforming	Finishing	_	re/Packaging	Other
NCR N	No.					Suspected Unapproved	ĺ		Large Fab	Composite		Supplier	
	<b>-</b>						<b>'</b>		·				
Root					Desci	ription of work order update	- 1	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Design						·							
Doc/Data	Ш												
Equip/Tooling													
Handling/Pre													
Material	Щ		!										
Operator	Щ												
Offset/Setup	Щ					,							
Process	Щ												
Supplier													
Training	Ш											]	
Transport	Щ					•							
Unapproved													,
							FAL	ULT CAT	regory				
Landi		I				General		l		Г	¬		٦. ، ا
	-	Bending			<u> </u>	Bend	$\vdash$		rogram	-	Outside Dim	<b>├</b>	Pressure/Forced
	$\vdash$	Centre No	ot Concer	ntric	$\vdash$	BOM/Route		Grain		-	Over/Under		Set-up
	${f H}$	Cracks	1 /0: - 1-	h	-	Broken/Damage/Defect	<u> </u>	Hardwa		<u> </u>	Part Incorre	<del> </del>	Temperature/Cure
	-	Crimp/Kir	к/кірріе	wave		Burrs	$\vdash$	1	ion Incomplete/U	<del> </del>	Part Lost/M	· -	Weld
	$\vdash$	Cuffs			-	Contamination	<u> </u>	1	ions Incomplete/	Unclear	Part Moved	<u>L</u>	Wrong Stock Pulled
	$\vdash$	Crushing			$\vdash$	Countersink	-	1	ned/off center	-	Positioned \	_	704h a r
	$\vdash$	Heat Trea		T Is -	<u> </u>	Cut Too Short	<u> </u>	Mislabe		L	Power Loss/	Surge	Other
	$\vdash$	Inspection	٠.	eauı	-	Drawing Drill Holos	$\vdash$	Misread	נ				
	-	Marks/Ch			-	Drill Holes	-	Off-set	Calibratia -			······································	
	$\vdash$	Turning So			-	Finish  Fit/Function	-	4	Calibration				

QC21- Final Inspection - Work Order Release

Memo

June-20-13 12:35:58 PM

150

OC

\*150\*

Quality Control

Item ID: D3901-1 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Bar **Start Date: Start Qty: 20.00** 6/20/13 Cust Item ID: Required Date: 7/04/13 Req'd Qty: 20.00 **Customer:** Reference: Run Process Plan: \_\_\_\_\_ Date: \_\_\_\_ Approvals: Tooling: Date: Stop SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool # Plan Tool ID Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Qty Code Qty Number Stamp

0.00

0.00

MB01.25

DQA:			Date:												TQ AC
						WORK ORDER NON	-CC	ONFO	RMANCE / UP					_	AEROSPACE
QA Closed:			Date:								Wo	ork Order up	date only	<u>L</u>	
Work Orde	er:					DISPOSITION				AGAINST	DEF	PARTMENT	/PROCESS		
	_				_	Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part N	No.					Scrap	1		Machining	Small Fab	ᅦ	Pro	d. Eng. Coor.	⊢	Quality
	_				_	Use-as-is	1		noforming	Finishing	$\exists$		re/Packaging	_	Other
NCR N	No.					Suspected Unapproved	1 1		Large Fab	Composite		·	Supplier	-	
Root					Descr	ription of work order update	1	Initial	Actio	on		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descrip	otion		Date	Verificatio	ก	QC Inspector
Design											l				
Doc/Data															
Equip/Tooling															
Handling/Pre	Ш														
Material	Ш														
Operator	Щ														
Offset/Setup															
Process	Н														
Supplier	$\vdash$														
Training	H														
Transport	Н														
Unapproved	<u> </u>		<u>.                                    </u>	<u> </u>			EAL	III T CA	TEGORY						
Landi	ng Ge	ar				General	r <sub>A</sub>	OLI CA	IEGORI			····			
201101		ending			Г	Bend		]Folio/F	Program	ſ		Outside Dim	ensions		Pressure/Forced
	${f oxed{f oxed{f eta}}}$	•	ot Concer	ntric		BOM/Route	$\vdash$	Grain	.08.4			Over/Under			Set-up
	$\vdash$	racks				Broken/Damage/Defect	$\vdash$	Hardwa	are		-	Part Incorred			Temperature/Cure
	$\Box_{c}$	rimp/Kir	nk/Ripple	/Wave		Burrs	$\vdash$	1	ion Incomplete/Ung	ualified	-	Part Lost/Mi		-	Weld
	$\Box_{c}$	uffs				Contamination		1	tions Incomplete/Ur	· •	-	Part Moved	0		Wrong Stock Pulled
		rushing				Countersink		4	gned/off center		-	Positioned V	Vrong		
		leat Trea	t			Cut Too Short		Mislabe				Power Loss/	-		Other
:		nspectio	n Strip in	Tube		Drawing		Misread	d			`	-		
		/larks/Ch	atter			Drill Holes		Off-set			•	<del></del>			<del>, , , , , , , , , , , , , , , , , , , </del>
	T	urning S	equence			Finish		Out of	Calibration		•				
	l Πν	Vave/Tw	ist in Tub	ne		Fit/Function		Out of	Seguence		•				

## **Picklist Print**

June-20-13 12:36:01 PM

Work Order ID: 103293

Parent Item:

D3901-1

Parent Item Name: Bar \*103293\*

\*D3901-1\*

**Start Date:** 6/20/13

Required Date: 7/04/13

**Start Qty: 20.00** 

Required Qty: 20.00

Comments:

IPP RevA: New issue DD verified by:EC

Now on cnc JFS 12/02/13 verified by:JLM

IPP RevB:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	•
M304B0.250x0.500		Purchased	No		100	f	181.4470	4.513	95.01053				
*M304R0 1	250~0 5	<b>'</b> '''						**	, , , , , , , , , , , , , , , , , , , ,				

## \*M304B0 250x0 500\*

304 BAR .250 x .500

<b>Location</b>	Loc Qty	Loc Code	
MAT049	181.447		
123902	0.992		
124518	53.855		<del></del>
m125804	126.6		

M126378 X 120

one 13/07/21

DQA:	-		Date:			WORK ORDER NON-	·cc	אובטו	DMANICE / III	DDATE				*DART	,
QA Closed:			Date:			WORK ORDER NON-			MINIAIRE / OI		Wor	k Order up	date only	AEROSPACE	
Work Orde	ır.					DISPOSITION				AGAINST [	DEP	ARTMENT/	PROCESS		
Part N	-					Rework Scrap			Skid-tube Machining	Crosstube Small Fab			Water Jet	Engineering Quality	
NCR N	۱o. ِ					Use-as-is Suspected Unapproved		inern	noforming Large Fab	Finishing Composite		Rec/Stor	e/Packaging Supplier	Other	
Root	·				Desc	ription of work order update	ı	nitial	Act	ion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	QC Inspector	
Design						·							,		
Doc/Data															
Equip/Tooling Handling/Pre															
Material			1												
Operator											-				
Offset/Setup															
Process															
Supplier	-							•							į
Training															
Transport															
Unapproved															
			<del>                                     </del>	<u>.</u>	<u>.                                    </u>		FAI	ULT CA	TEGORY		- 1				_
Landi	ng (	Gear				General		•							_
	Ť	Bending				Bend		Folio/F	rogram	[		Outside Dim	ensions	Pressure/Forced	
		Centre No	ot Conce	ntric		BOM/Route		Grain	J	Ĭ		Over/Under	tolerance	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	ire	ļ	T F	Part Incorrec	t T	Temperature/Cure	
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	ngualified	F	Part Lost/Mi	ssing	Weld	
		Cuffs				Contamination		1	ions Incomplete/U	· · · · · · · · · · · · · · · · · · ·	$\overline{}$	Part Moved	-	Wrong Stock Pulled	
		Crushing				Countersink		4	ned/off center	t	_	Positioned W	 ∕rong	<b>_</b>	
		Heat Trea	it			Cut Too Short		Mislabe		ļ		ower Loss/		Other	
		Inspection	n Strip in	Tube		Drawing		Misrea	t				-		_
		Marks/Ch	atter			Drill Holes		Off-set			_	· · · · · · · · · · · · · · · · · · ·			
		Turning S	equence			Finish		Out of	Calibration		-				
		Wave/Tw	ist in Tub	ре		Fit/Function		Out of	Sequence						_

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

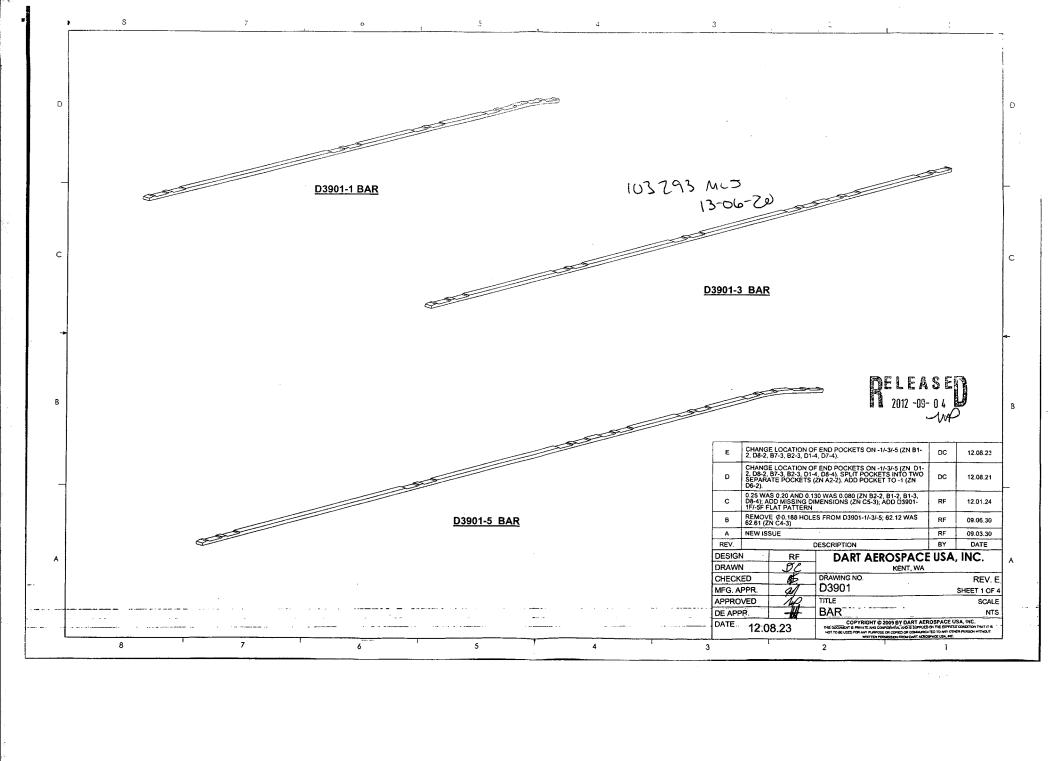
DART AEROSPACE LTD	Work Order:	103293
Description: Bar	Part Number:	D3901-1
Inspection Dwg: D3901 Rev: E		Page 1 of 1

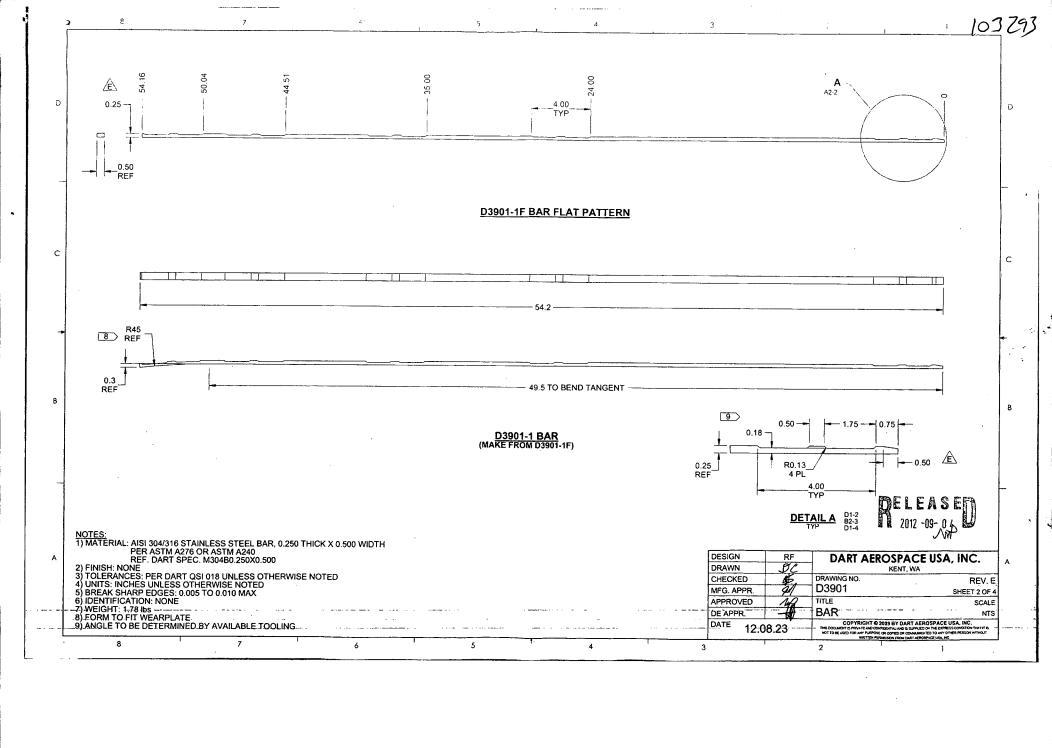
## FIRST ARTICLE INSPECTION CHECKLIST

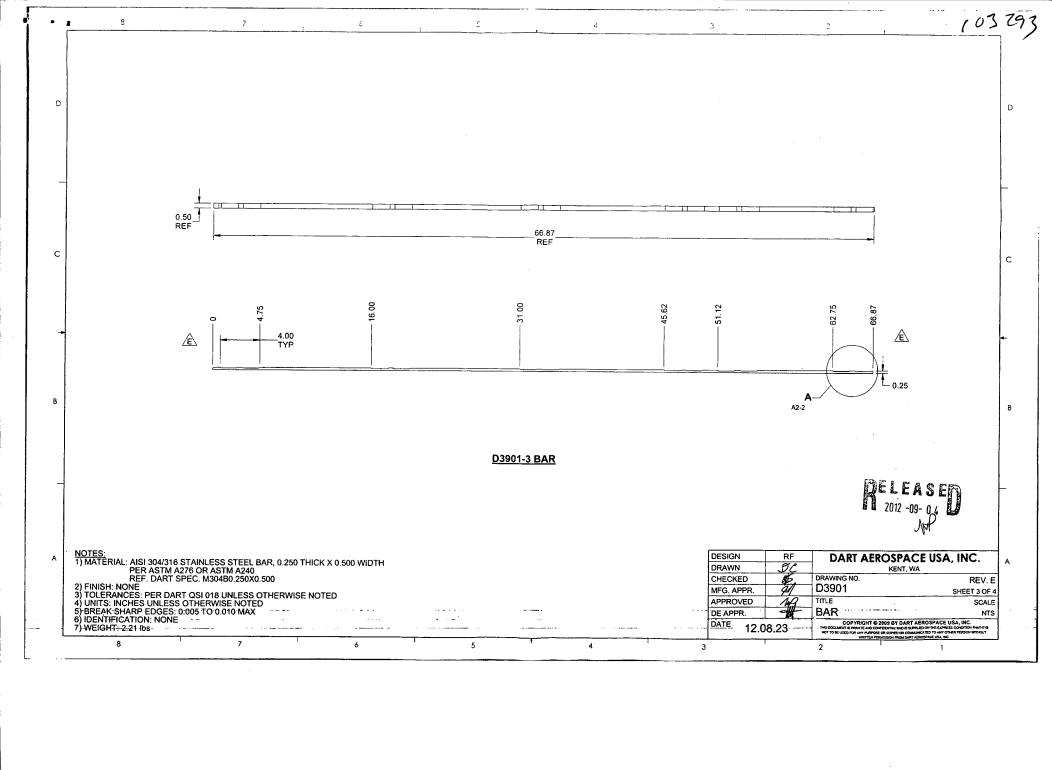
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.25 Ref	+/-0.030	. 25				,
4.00	+/-0.030	4.00				
24.00	+/-0.030	24.00				
35.00	+/-0.030	35.00				
44.51	+/-0.030	44.5/				
50.04	+/-0.100	86.04				
0.18	+/-0.030	.18				
0.50 Ref	+/-0.030	-50				
0.75	+/-0.030	- 75				
0.50	+/-0.030	.50				
1.75	+/-0.030	1.78				
0.50	+/-0.030	. 50				
			-1			

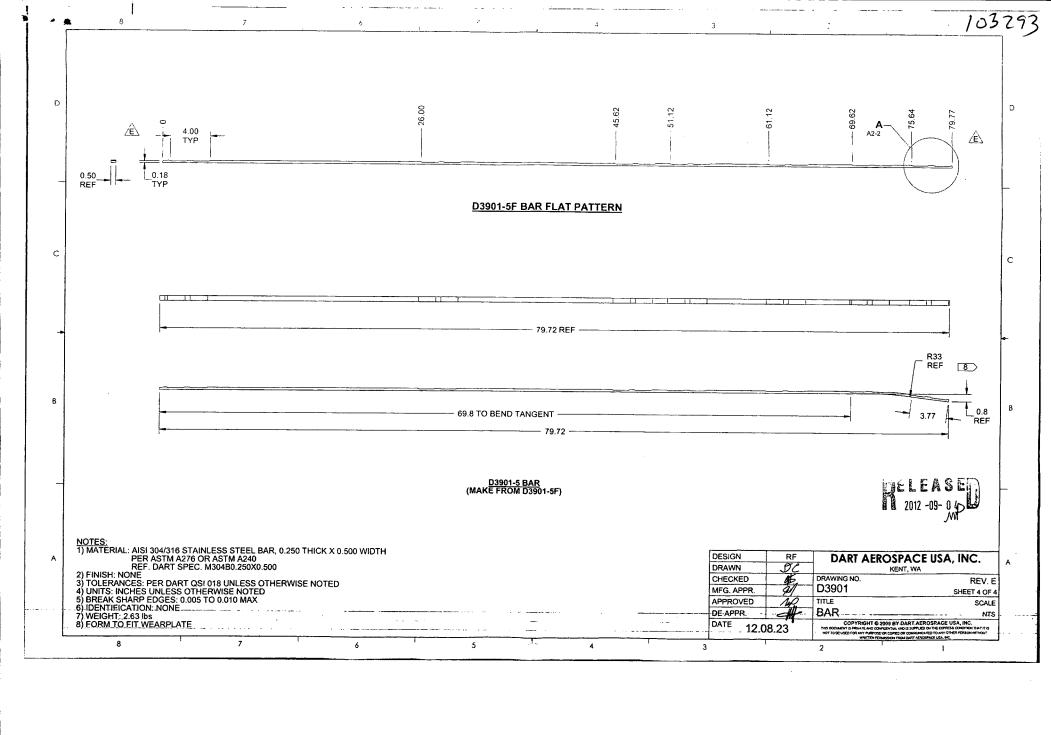
Measured by:	RA	Audited by:	onl	Preliminary Approval:	
Date:	13/07/24	Date:	13/07/25	- Date:	,

Rev	Date	Change	Revised by	Approved
Α	09.09.15	New Issue	KJ	
В	12.07.31	Dimensions updated per Dwg Rev C	KJ (A	2/
С	12.09.26	Dimensions updated per Dwg Rev E	KJ 94	(/1/
	1 12:00:20			- June









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ili≱ Marie e dite			1	